

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029687**Date Inspected:** 16-May-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

This QA Inspector randomly observed ABF welder Eric Sparks #3040 perform the Shielded Metal Arc Welding (SMAW) process on the hand rail posts at the luminaire pedestal located at 10W PP88.5-W5. The welder was observed utilizing WPS ABF-D1.5-F1200A-Revision 1. The welder was observed preheating the surface area prior to welding and other welding parameters as inspected by the QC Inspector were recorded as 134 amperes and appeared to be in compliance with the WPS noted above. The QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

This QA Inspector randomly observed ABF welder Jose Torres #6235 perform the SMAW process on the hand rail post pad eyes (6) located at 2W PP13.5-W5. The welder was observed utilizing WPS ABF-D1.5-F1200A-Revision 1. The welder was observed preheating the surface area prior to welding and other welding parameters as inspected by the QC Inspector were recorded as 134 amperes and appeared to be in compliance with the WPS noted above. The QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

This QA Inspector randomly observed ABF welder Eric Sparks #3040 perform the SMAW process on the hand

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rail post pad eyes (6) located at 13E PP118-E5. The welder was observed utilizing WPS ABF-D1.5-F1200A-Revision 1. The welder was observed preheating the surface area prior to welding and other welding parameters as inspected by the QC Inspector were recorded as 134 amperes and appeared to be in compliance with the WPS noted above. The QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

This QA Inspector randomly observed ABF welder Guo Wu Chen #1556 perform the SMAW process on the PS3 pipe brackets located at locations PP95, PP97, PP99, PP101 and PP103. The welder was observed utilizing WPS ABF-D1.5-F1200A-Revision 1. The welder was observed preheating the surface area prior to welding and other welding parameters as inspected by the QC Inspector were recorded as 138 amperes and appeared to be in compliance with the WPS noted above. The QA Inspector made subsequent observations throughout the shift to monitor quality and noted that the work was completed on this date and appeared to be in general conformance with the contract documents.

FW Spencer welder Rick Kiikvee #5319 was observed performing SMAW welding on 4" schedule 40 pipe. The welder was observed utilizing WPS-1-12-1 and the welder was observed pre-heating the surface area to be welded prior to welding. Other welding parameters as inspected by the QC Inspector appeared to be in compliance with the WPS noted above. This QA Inspector made random observations throughout the shift and noted that the work was completed on this date and appeared to be in general conformance with the contract documents. Completed work on this date includes weld identification #'s; 30/4/39/BE and 31/4/41/BE.

This QA observed QC Inspector William Sherwood and Salvador Merino performing welding parameter checks such as voltage, amps, electrodes and preheats throughout the day. Non-Destructive Testing methods utilized by the QC Inspectors were Visual Testing (VT), Magnetic Particle Testing (MPT). QC Inspectors were observed performing inspection per applicable code and or contract criteria. Unless otherwise noted, all work observed on this date appeared to generally comply with the contract documents.

### Summary of Conversations:

Conversations on this date were relevant to work performed.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas 916-764-6027 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Frey,Doug	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes,Danny	QA Reviewer

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